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No. 31—1910.

British Engineering Standards Association.

(Incorporated 1918.)

FORMED IN 1901 AS THE ENGINEERING STANDARDS COMMITTEE
BY
THE INSTITUTION OF CIVIL ENGINEERS.
THE INSTITUTION OF MECHANICAL ENGINEERS.
THE INSTITUTION OF NAVAL ARCHITECTS.
THE IRON AND STEEL INSTITUTE.
THE INSTITUTION OF ELECTRICAL ENGINEERS.

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BRITISH

STANDARD SPECIFICATION

FOR

STEEL CONDUITS FOR ELECTRICAL WIRING.

(REVISED SEPTEMBER, 1910.)

LONDON:
PUBLISHED FOR THE ASSOCIATION BY CROSBY LOCKWOOD & SON,
7, STATIONERS' HALL COURT, LUDGATE HILL, E.C.4; AND 5, BROADWAY, WESTMINSTER, S.W.1;
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May, 1918.

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† Succeeded the late SIR JOHN WOLFE BARRY, K.C.B., February, 1918.

BRITISH ENGINEERING STANDARDS ASSOCIATION.

The following are lists of Members of the Sectional Committee on Electrical Plant and of the Sub-Committee on Electrical Plant Accessories who have had the revision of this Specification under consideration.

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September, 1910.

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* Since deceased.

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September, 1910.

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* Since deceased.

PREFACE TO FIRST EDITION.

The Sub-Committee on Electrical Plant Accessories was appointed at a Meeting of the Sectional Committee on Electrical Plant (SIR WILLIAM H. PREECE, K.C.B., *Chairman*), held on January 15th, 1903, which appointment was confirmed by the Main Committee on December 8th, 1904.

The desirability of standardising Steel Conduits for Electrical Wiring was brought to the notice of this Sub-Committee in February, 1906. The Manufacturers of Steel Conduits for Electrical Wiring accepted the invitation of the Committee to give evidence on the subject, and on March 6th, 1906, the Sub-Committee sat at the Institution of Civil Engineers to hear this evidence. Most careful consideration has been given to the evidence submitted by the several witnesses, and measurements have been carried out on Conduits at the National Physical Laboratory.

The Sectional Committee on Screw Threads and Limit Gauges has been consulted with regard to the question of threads. The clauses dealing with gauging have been based on the recommendations of that Committee.

This Report was adopted by the Sectional Committee on Electrical Plant at their Meeting held on July 18th, 1906.

This Report was approved by the Main Committee at their Meeting held on July 26th, 1906.

C. H. WORDINGHAM,
Chairman of the Sub-Committee on Electrical Plant Accessories.

PREFACE TO SECOND EDITION.

Difficulties having arisen in the practical carrying out of this Specification, due to the obliteration of the Inspector's stamp by the galvanizing process, the Committee have revised the Clauses dealing with the gauging, so as to allow of the tubes being gauged after instead of before galvanising. In order also to provide a more satisfactory joint, modifications have been introduced in regard to the length of thread on the end of the tubes, so as to prevent the tubes butting in the coupler.

This Report in its present form was adopted by the Sectional Committee on Electrical Plant at their Meeting held on July 19th, 1910.

This Report in its present form was approved by the Main Committee at their Meeting held on July 22nd, 1910.

C. H. WORDINGHAM,
Chairman of the Sub-Committee on Electrical Plant Accessories.

Note.—The Association desires to call attention to the fact that this Specification is intended to include the technical provisions necessary for the supply of the material herein referred to, but does not purport to include all the necessary provisions of a Contract.

BRITISH STANDARD SPECIFICATION FOR STEEL CONDUITS FOR ELECTRICAL WIRING.

(REVISED SEPTEMBER, 1910.)

Material and Method of Manufacture.

1. Steel Conduits for Electrical Wiring shall be either close-joint[1], brazed, welded or solid drawn. They shall be of mild steel free from burrs, flaws or other defects. They and their Accessories, when these are made of steel or iron, shall be stove enamelled or galvanized inside and out by an approved process.

Classification.

2. Two classes of Steel Conduit for Electrical Wiring are recognised as Standard :—

(A) Plain.
(B) Screwed.

Class (A) consists of light gauge Conduit of the thicknesses and dimensions given in the annexed Table. The Socket joining the lengths of tubing is a sleeve, and neither the ends of the Conduit nor the Socket are screwed.

Class (B) consists of heavy gauge Conduit of the thicknesses and dimensions given in the annexed Table. Both ends of the Conduit are screwed with the Whitworth[2] form of thread as defined in the Committee's Report on British Standard Pipe Threads (Publication No. 21 Revised November, 1909), Clause 2. The Couplers are also screwed inside throughout their entire length with a right-handed thread of Whitworth form, but having the number of threads per inch given in the annexed Table. The screwed portions of both Conduits and Couplers are not enamelled.

[1] In the close-joint tubes, the edges of the steel strip, although brought tightly together in the process of manufacture, are not metallically joined in any way.

[2] In this thread the angle between the slopes measured in the axial plane is 55°, the threads are rounded equally at crest and roots, leaving a depth of thread approximately equal to 0·64 times the pitch.

Outside Diameter.

3. Both classes of Conduit shall be manufactured to the respective outside diameters given in the annexed Table.

Length.

4. Both classes of Conduit shall be manufactured in straight lengths of ten, twelve or fourteen feet.

Thickness.

5. Both classes of Conduit and Accessories shall be manufactured to the respective thicknesses given in the annexed Table.

Plain Sockets.

6. The combined length and thickness of the recessed portions of Plain Sockets is given in the annexed Table. The thickness is approximately equal to one and a half times that of the corresponding Conduit, and the length is determined by the following formula in which L = Combined length of recessed portions of Socket in inches and D = Outside diameter of Conduit in inches.

$$L = (2\ D + 1) \text{ inches.}$$

Screwed Couplers.

7. The length and thickness of Couplers is given in the annexed Table. The thickness before screwing is equal to twice that of the corresponding Conduit, and the length is determined by the following formula in which L = Length of Coupler in inches and D = Outside diameter of Conduit in inches.

$$L = (D + \tfrac{1}{2}) \text{ inches.}$$

Length of Thread.

8. The length of thread on the ends of Conduits, which shall be the same for Bends, Tees, Junction-Boxes and all other screwed Accessories, is given in the annexed Table, and is determined by the following formula in which L = Length of Thread in inches and D = Outside diameter of Conduit in inches.

$$L = \tfrac{1}{2}\ (D + \tfrac{3}{8}) \text{ inches.}$$

Minimum Radius and Thickness of Bends.

9. The minimum radius of any Bend, in inches, measured from the centre of curvature to the axis of the Bend is given in the annexed Table.

The thickness of any Bend or Tee shall be not less than that of the corresponding straight length.

Gauging.

10. Conduits and their Accessories shall be gauged at the Works of the Manufacturer, before enamelling or after galvanising, as the case may be, as follows :—

(*a*) *Conduits, Outside Diameter.*—One per cent. of any batch of Conduits (never less than one standard straight

length) shall be selected at random *before* enamelling or *after* galvanizing, and be gauged for correctness of outside diameter. (See Clause No. 13.)

(*b*) *Conduits, Thickness.*—Not less than one hundred feet (100 feet) of any batch of Conduits shall be selected at random *before* enamelling or *after* galvanizing, and be tested for average thickness by weighing. (See Clause No. 14.)

(*c*) *Sockets, Couplers, Inside Diameter, Thickness.*— One per cent. of any batch of plain Sockets or Accessories shall be selected at random *before* enamelling or *after* galvanizing and be gauged for correctness of inside diameter and thickness. (See Clause No. 15.) One per cent. of any batch of Couplers or screwed Accessories shall be selected at random *before* screwing and be gauged for thickness. (See Clause No. 15.)

(*d*) *Conduits, Couplers, Screwing.*—One per cent. of any batch of screwed Conduits (never less than one standard straight length) or of Couplers shall be selected at random and be gauged for correctness of thread. (See Clause No. 16.)

Additional Gauging before Rejection.

11. Should the Conduits, Sockets, Couplers or other Accessories first selected for gauging prove unsatisfactory a further selection of samples may be made and gauged under the terms of Clause No. 10.

Rejection.

12. Should the Conduits, Sockets, Couplers or other Accessories examined not comply with the terms of this Specification the whole batch from which the samples were selected shall be rejected.

RECOMMENDATIONS AS TO GAUGING.

Outside Diameter.

13. The outside diameters of Conduits should be gauged by means of Limit Gauges. As a different variation in outside Diameter is permitted on the two classes of Conduit, the Committee recommend that the maximum diameter of each class should be the same and the permissible variations negative. Consequently it will be necessary that the complete limit gauge for each size should have three jaws, viz. :—

A "*Go*" for all Conduits	[D + ·002″]	VARIATION—
A "*Not Go*" for Class (A)	[D − ·002″]	Class (A) ... ·004
A "*Not Go*" for Class (B)	[D − ·004″]	Class (B) ... ·006

Thickness.

14. The average thickness of Steel Conduits should be determined by weighing not less than one hundred feet (100 ft.) The weight should fall within the margins given in the annexed Table.

Inside and Outside Diameters of Accessories.

15. The Inside and Outside Diameters of Plain Sockets, Couplers and Accessories should be gauged by means of the following Limit Gauges:—

VARIATION CLASS (A) ... ·004″

1. (*a*) A "*Go*" gauge for inside diameter of Plain Sockets [D + ·002″]
   (*b*) A "*Not Go*" " " " " " [D + ·006″]
2. (*a*) A "*Go*" " outside " " " [D + 2*t* + ·002″]
   (*b*) A "*Not Go*" " " " " " [D + 2*t* − ·002″]

VARIATION CLASS (B) ... ·006″

3. (*a*) A "*Go*" gauge for inside dia. of Couplers before screwing [D − 2*d* + ·002″]
   (*b*) A "*Not Go*" gauge for inside dia. of Couplers before screwing [D − 2*d* + ·008″]
4. (*a*) A "*Go*" gauge for outside dia. of Couplers before screwing [D − 2*d* + 2T + ·003″]
   (*b*) A "*Not Go*" gauge for outside dia. of Couplers before screwing [D − 2*d* + 2T − ·003″]

D = Outside Diameter in inches.
T = Thickness of Coupler ,,
t = Thickness of Socket ,,
d = Depth of Thread ,,

Screw Thread.

16. The Screw Threads on the ends of Conduits Class (B) and in Couplers and Accessories should be gauged by means of male and female screwed gauges, in accordance with the recommendations contained in the Committee's Report on British Standard Pipe Threads (Publication No. 21 Revised November, 1909).

Three classes of screwed gauges are recognised, namely:

(1.) *Standard Screwed Gauges.*

(2.) *Reference Screwed Gauges.*

(3.) *Shop Screwed Gauges.*

These Gauges should be complete screwed, ring and plug Gauges, screwed parallel with the Whitworth form of Thread to the Pitches given in the annexed Table.

It must be distinctly understood that these screwed gauges are not limit gauges, and the passing or rejection of any Conduit or Coupler as regards correctness of thread will depend on the discretion of the Inspector in declaring the fit of the gauge on the Conduit-end or in the Coupler as satisfactory or not.

Checking of Gauges.

17. The recommendations with regard to gauging laid down by the Sectional Committee on Screw Threads and Limit Gauges have been adopted by this Sub-Committee. In order that the Gauges used in the Shops may be reasonably accurate, the Shop Gauges should be checked against Reference Gauges. The Reference Gauges are, however, subject to a certain amount of wear themselves, and should therefore be checked against Standard Gauges.

The definitions of these three Classes of Gauges are as follows :—

(A) *Standard Gauges.*—These are Gauges made in accordance with the Dimensions given in the annexed Table and with the greatest possible accuracy. They are deposited with the National Physical Laboratory for purposes of reference. There will be seven Gauges for each Standard size of Conduit, Socket and Coupler to gauge the following :—

(1.) Outside Diameter of Conduit.
(2.) Inside Diameter of Socket.
(3.) Inside Diameter of Coupler.
(4.) Outside Diameter of Socket.
(5.) Outside Diameter of Coupler.
(6.) Thread on end of Conduit.
(7.) Thread in Coupler.

(B) *Reference Gauges.*—These are copies of the foregoing Standard Gauges for use by Manufacturers and others for checking their own shop gauges. They should be verified, and their accuracy certified by the National Physical Laboratory.

(C) *Shop Gauges.*—These are Gauges actually used in the shop and checked against the Reference Gauges.

TABLE
OF
STANDARD DIMENSIONS OF STEEL CONDUITS.

Outside diameter in inches			⅜	½	1	1¼	1½	2
Threads per inch			18	16	16	16	14	14
Depth of thread in inches			·0356	·0400	·0400	·0400	·0457	·0457
Maximum length of thread on end of Conduit in inches			½	9/16	11/16	13/16	15/16	1 3/16
Minimum length of thread on end of Conduit in inches			7/16	½	⅝	¾	⅞	1 1/16
Nominal Thickness	Class (A)	S.W.G. (inches)	19 (·040)	18 (·048)	18 (·048)	17 (·056)	16 (·064)	16 (·064)
	Class (B)	S.W.G. (inches)	16 (·064)	15 (·072)	15 (·072)	15 (·072)	14 (·080)	13 (·092)
Weight per 100 ft. in lbs.	Class (A)	Max. ...	28·9	40·8	55·4	79·9	108·7	146·7
		Min. ...	23·6	34·4	46·6	68·9	95·4	128·1
	Class (B)	Max. ...	42·2	56·9	78·1	99·3	132·1	202·4
		Min. ...	37·4	51·0	69·8	88·5	119·0	184·7
Combined lengths of recessed portions of Plain Sockets in inches ...			2¼	2½	3	3½	4	5
Thickness of Plain Socket in inches			·060	·072	·072	·084	·096	·096
Length of Coupler in inches			1⅝	1¾	1½	1⅞	2	2½
Thickness of Coupler in inches (before screwing) ...			·128	·144	·144	·144	·160	·184
Minimum radius of Bends in inches			1⅝	2	2½	3¾	5¼	8½

British Engineering Standards Association.

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NOVEMBER, 1918.

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